

Work Order ID 69811

Thursday, May 19, 2011 2:30:16 PM



Page 1

Item ID: D4154-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 5/19/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/25/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-05-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4154	B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *[Signature]*

Prog Rev: *[Signature]*

2-Deburr if necessary

B11-6-8

(6)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-6-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S 11/06/08

(H)

130

Form as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

SB 11/06/14

(6)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 11/06/14

(x6)

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Page 3

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Setup Start



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Cust Item ID:

Required Date: 5/25/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: *W/A*

0.00



Packaging

Memo

0.00

Packaging

*EL 11-7-8**(x6)*

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/7/11**MF**11-07-08*

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, May 19, 2011 2:30:22 PM

Page 1

Work Order ID: 69811

Parent Item: D4154-1

Parent Item Name: Plate



Start Date: 5/19/2011

Required Date: 5/25/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	180.0000	4.2697	26.96653			



304/316 .050 Sheet



B11-6-8

Location

Loc Qty

Loc Code

MAT020

180

112178

4

113062

18

116135

20.5

116604

1.5

116979

69

117653

67

17653

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 68811
Description: Plate		Part Number: D4154-1
Inspection Dwg: D4154	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.400	+/-0.010	.402	x		V RBG 2	
0.450	+/-0.010	.451	x		V	
0.125	+/-0.010	.128	x		V	
0.88	+/-0.030	.88	2		V	
1.19	+/-0.030	1.19	x		V	
5.273	+/-0.010	5.272	x		V	
2.75	+/-0.030	2.75	x		V	
15.80	+/-0.030	15.80	x		T RBG 1	
3.95	+/-0.030	3.953	x		V	
4.00	+/-0.030	3.997	x		V	
6.42	+/-0.030	6.417	x		V	
21.75	+/-0.030	21.75	x		T	
4.35	+/-0.030	4.34	x		V	
1.80	+/-0.030	1.810	x		V	
21.31	+/-0.030	21.31	x		T	
4.26	+/-0.030	4.257	x		V	
8.83	+/-0.030	8.834	x		T	
5.16	+/-0.030	5.160	x		V	
0.55	+/-0.030	.551	x		V	
91.56	+/-0.030	91.56	x		T	
90.41	+/-0.030	90.41	x		T	
74.45	+/-0.030	74.45	x		T	
66.51	+/-0.030	66.51	x		T	
48.59	+/-0.030	48.59	x		T	
40.76	+/-0.030	40.76	x		T	
15.45	+/-0.030	15.46	x		T	
5.223	+/-0.010	5.220	x		V	
Ø0.516	+0.008/-0.001	.516	x		V	
Ø0.188	+0.005/-0.001	.182	x		V	
0.050	+/-0.010	.047	x		V	

Measured by: RB	Audited by: S	Preliminary Approval:
Date: 11-6-8	Date: 11/06/08	Date:

Rev	Date	Change	Revised by	Approved
A	10.09.23	New Issue	KJ	
b	11.04.28	Dimensions updated per Dwg Rev B	KJ	

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 6984

11-05-19

D4154-041 WEARPLATE ASSEMBLY

ITEM	QTY	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2059B	HARDCOAT
4	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 11, SHT 2)

RELEASED
2011-04-10

B	ITEM 4 WAS PR1422 (D3-1); REMOVED FINISH TO NOTE 2 (AB-2); REMOVED SECTION A-A (NO LONGER REQUIRED); REVISED D4154-1F		MB	11.04.05
A	NEW ISSUE		SC	10.07.22
REV.	DESCRIPTION		BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.		
DRAWN	<i>[Signature]</i>	PORT HADLOCK, WA		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>[Signature]</i>	D4154	SHEET 1 OF 3	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSEMBLY	NTS	
DATE	11.04.05		<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

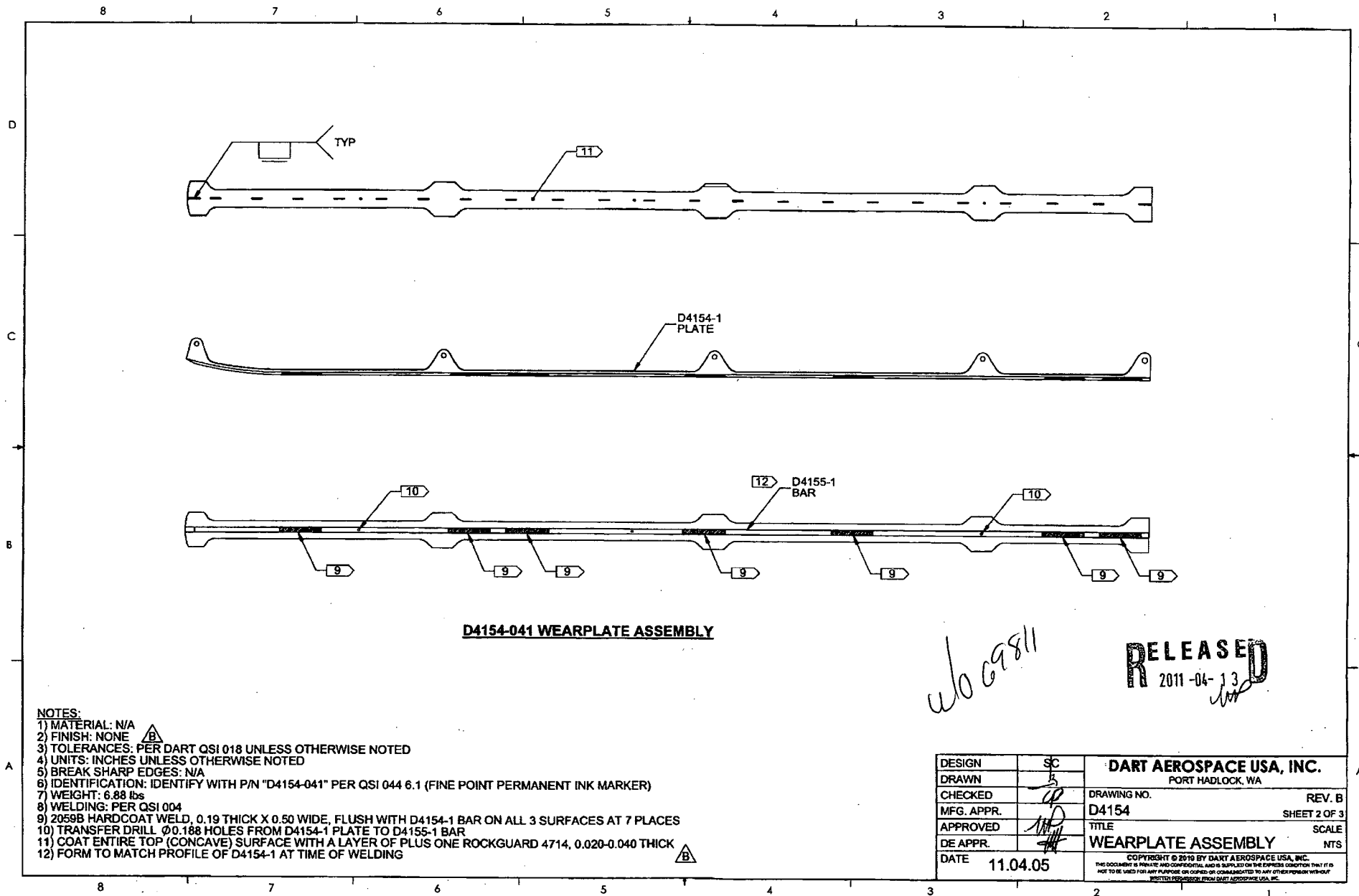
W/O:		WORK ORDER CHANGES					
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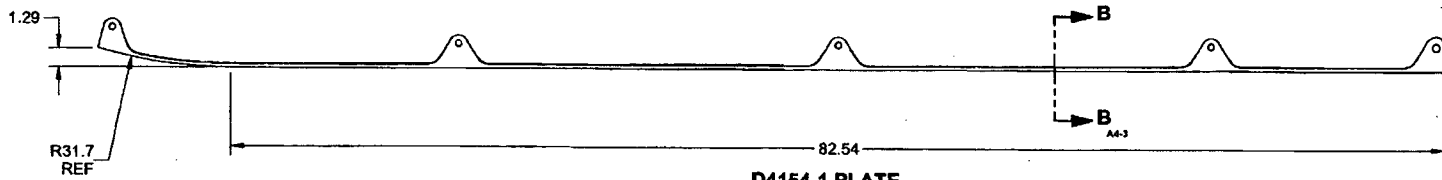
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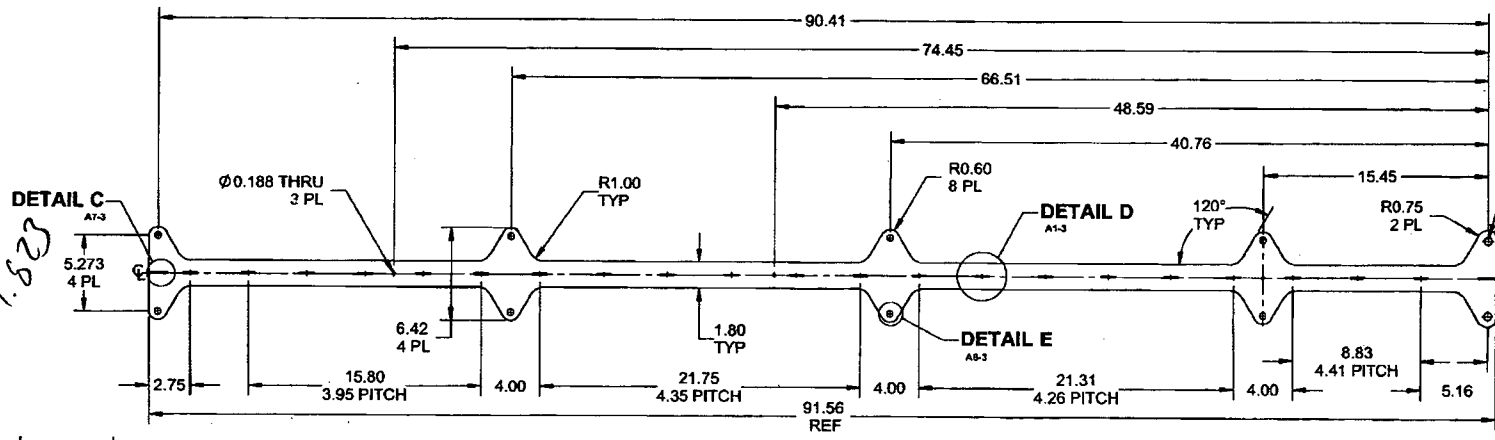
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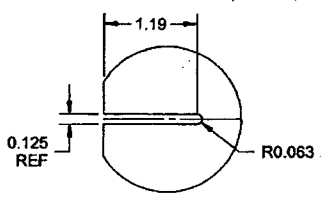
8 7 6 5 4 3 2 1



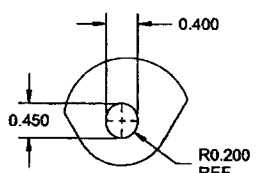
D4154-1 PLATE
(MAKE FROM D4154-1F)



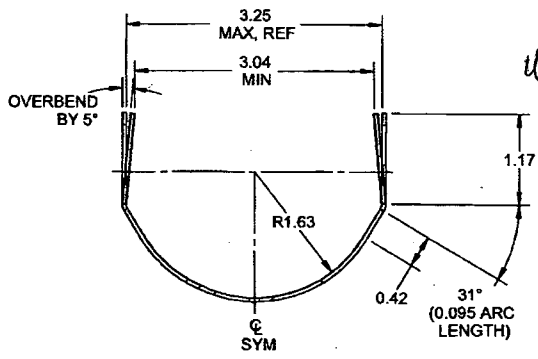
D4154-1F FLAT PATTERN



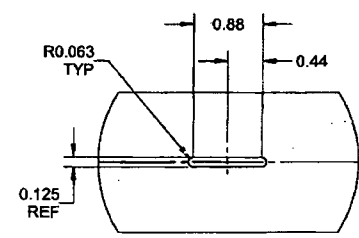
DETAIL C
END SLOT DETAIL, 2 PL



DETAIL E
SLOT DETAIL TYP



SECTION B-B



DETAIL D
SLOT DETAIL TYP

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 2.95 lbs

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4154	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
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RELEASED
2011-04-13

4.707

u60984

W/O:		WORK ORDER CHANGES					
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